

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004458**Date Inspected:** 27-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wen Pang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Tower**Summary of Items Observed:**

The Caltrans (CT) Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

**OBG Sub-Assembly Bay 4:**

The QA Inspector randomly observed ZPMC Non-Destructive Testing (NDT) Technician Zhou Dongyun, utilizing the Magnetic Particle Testing (MT) Method to perform a final MT examination of the cover pass of all the welds on Side Plate Sub-Assemblies SP478-00 WJ's 001 through 014, SP759-001 WJ's 013 through 024 and Bottom Plate Sub-Assembly BP116-001 WJ's 001 through 012. There appeared to be no indications and ZPMC QC accepted all the above listed welds.

The QA Inspector performed a 10% final Visual (VT) and MT verification on the cover pass of all the welds on Side Plate Sub-Assemblies SP478-00 WJ's 001 through 014 (Green Tag 001245), SP759-001 WJ's 013 through 024 (Green Tag 001242 and Bottom Plate Sub-Assembly BP116-001 WJ's 001 through 012 (Green Tag 001243). There appeared to be no indications the QA Inspector accepted all of the above listed welds. The attached photograph provides additional detail.

**OBG Sub-Assembly Bay 7:**

The QA Inspector randomly observed ZPMC NDT Technician Zhou Dongyun, utilizing the MT Method to perform

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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a final MT examination of the cover pass of all the welds on Floor Beam Wing Diaphragms FB015-028 (Side A) and FB016-028 (Side A). There appeared to be no indications and ZPMC QC accepted all welds on FB015-028 (Side A) and FB016-028 (Side A).

The QA Inspector then performed a 10% final VT and MT verification on the cover pass of all the welds on Floor Beam Wing Diaphragms FB015-028 (Side A) FB016-028 (Side A). There appeared to be no indications the QA Inspector accepted all welds on the above listed Floor Beam Wing Diaphragms.



### Summary of Conversations:

There were no relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Josh Ishibashi 13764716411, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Franco,Charlie	Quality Assurance Inspector
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<b>Reviewed By:</b>	Wright,Mark	QA Reviewer
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